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**CONFIDENTIAL**  
**FORTY-FIFTH**  
**PROGRESS REPORT**

**OF**  
**THE FIRESTONE TIRE & RUBBER COMPANY**  
**ON**  
**BATTALION ANTI-TANK PROJECT**  
**UNDER**

**Contract No. DA-33-019-GRD-1202**  
**ORDNANCE DEPARTMENT PROJECTS**  
**TS4-4020-WEAPONS AND ACCESSORIES**  
**TM1-1540-AMMUNITION**

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**THE FIRESTONE TIRE & RUBBER COMPANY**  
**Defense Research Division**  
**Akron, Ohio**

**APRIL 1954**

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**FORTY-FIFTH  
PROGRESS REPORT  
OF  
THE FIRESTONE TIRE & RUBBER CO.  
ON  
BATTALION ANTI-TANK PROJECT**

**Contract No.  
DA-33-019-ORD-1202**

**RAD Nos. ORDTS 3-3955  
ORDTS 3-3957  
ORDTA 3-3952**

**THE FIRESTONE TIRE & RUBBER CO.  
Defense Research Division  
Akron, Ohio  
APRIL, 1954**

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## ABSTRACT

General Projectile Design Considerations - In considering a 90mm weapon and ammunition for the requirements of the ultimate BAT system it is necessary to obtain penetration performance equivalent to that of the 105mm round. To reach this performance the cone size of the 90mm round must be approximately equivalent to that of the 105mm round. In order to use a cone of this size a method of assembly, using plastic bonding agents has been devised. This method permits thinner wall sections and hence larger diameter cones. The method to be used in bonding the ogive and body has been tested in the laboratory and the strength of the union measured. The test procedure and results are discussed here. It was found that the walls of the components failed before the separation of the cemented joint.

A new fin assembly has been designed for folding fin type projectiles. The new assembly is in the 90mm size but the design can be adapted to other sizes as well. The new assembly has fewer parts, provides more positive locking of the fins and is designed so that more generous tolerances are permissible. The new design is illustrated and described.

Fuzes - Laboratory tests have been conducted to compare a new potted "Lucky" nose element with the present package unit. The test data are presented.

Fourteen rounds containing T267E14 base elements were fired for functioning evaluation at Erie Ordnance Depot. Six rounds functioned as set and eight rounds functioned either improperly or not at all. Because of poor conditions for observation the test is to be repeated.

Fourteen T267E14 base elements were fired at Aberdeen Proving Ground for graze sensitivity tests. Seven rounds functioned high order, 3 functioned low order and 4 rounds did not function. The test results are tabulated.

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## GENERAL PROJECTILE DESIGN CONSIDERATIONS

### Design To Increase Diameter Of Conical Liner Diameter

In considering a 90mm weapon and ammunition for the requirements of the ultimate BAT system the penetrating ability is one of the prime considerations. Since comparative performance is the basis for selection of the caliber of the ultimate weapon and ammunition it is necessary to obtain penetration performance with the 90mm round equivalent to that of the 105mm T119E11 (M344) projectile. Since the penetration performance of shaped charges scales approximately linearly with cone diameter, it is evident that a

proposed 90mm shell will penetrate as deeply as an existing 105mm size only when (1) the cones are of nearly the same effective diameter or (2) if the general level of shaped charge performance is improved.

Fig. 1 shows views of a 105mm HEAT round (T119E11) and the E1 modification of the 90mm BAT round designed by Firestone. In this E1 modification the effective cone diameter is 2.748 in compared with 3.555 in for the 105mm HEAT round, T119E11. In order to lessen this differential, investigations are being made into new methods of assembly of the cone, body and ogive.

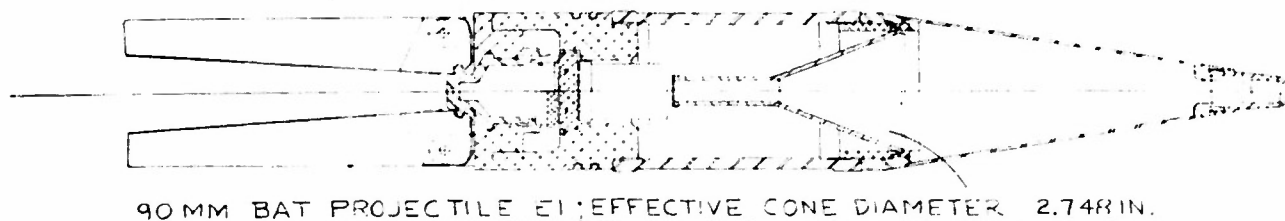
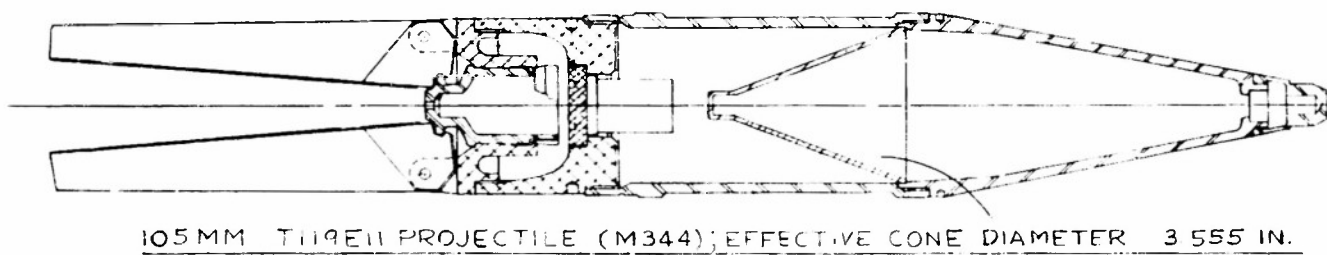


Fig. 1. Views Of Two Projectile Designs.  
105 mm. BAT T119E11 (M344) and 90 mm. BAT E1.

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## Assembly Of Projectile Components With Plastic Bonding Agent

Fig. 2 shows the E2 modification of the BAT 90mm projectile, using a cone with an effective diameter of 3.248 in only 8.6% less than in the 105mm round. The assembly, shown in Fig. 2, is made by registering the cone in the body and locking it in place by crimping the flange down over the cone edge. The ogive is then cemented, pressed on the body and cured at approximately 200°F. The following tests have been conducted on this cemented joint.

## Shear Strength Of Bonding Agent

Six test units were prepared as shown in Fig. 3. When the two pieces were assembled as shown, there was a circular lap joint 15/16 in. long. The other end of the test cylinders were machined to accommodate fixtures for applying a tensile load to produce simple shear across the joint.

The samples were carefully measured to determine the clearance within the joint, and the amount of ovality and the surface finish were noted. Table I shows these data.

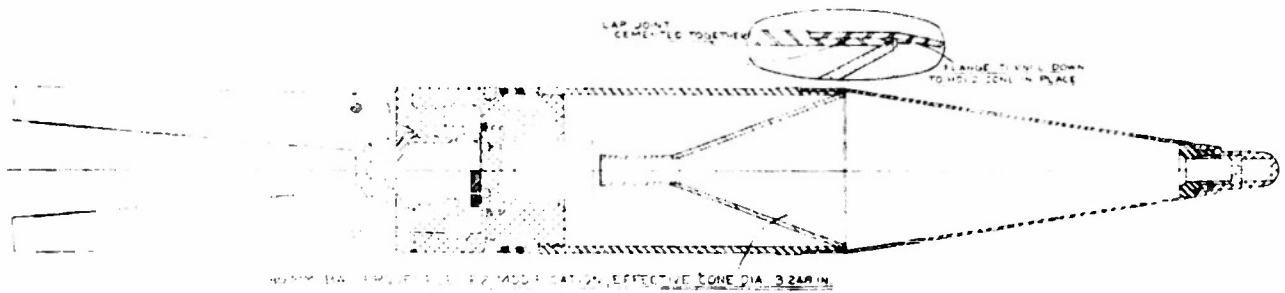


Fig. 2. 90 mm. BAT Projectile, E2 Modification.  
Showing Assembly By Means Of Plastic Bonding Agent.

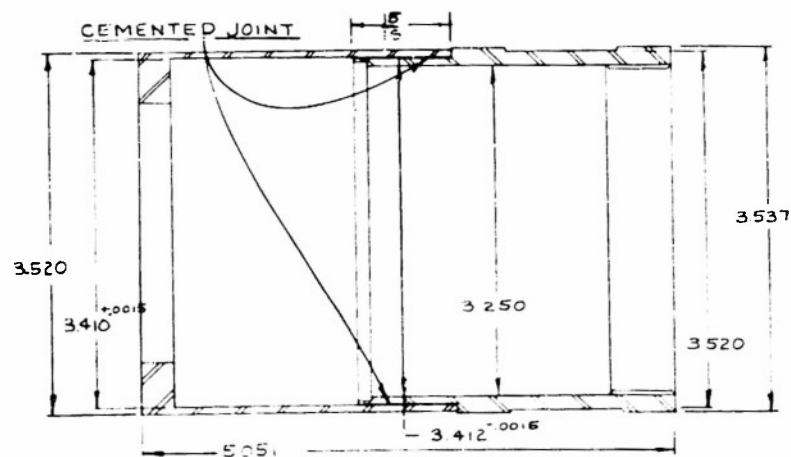


Fig. 3. Test Unit For Measuring Shear Strength Of Bonding Agent.



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**Table I**  
**Inspection Data**  
**Six Sample Test Assemblies**

Sample	Avg. O.D.		Clearance Avg (in)	Ovality		Area of Joint (Calc.) (sq in)	Finish in Micro Inches	
	Male (in.)	Female (in.)		Male (in)	Female (in)		Male	Female
1	3.407	3.415	.004	.0015	.002	10.2	130	140
2	3.408	3.417	.0045	.0005	0	10.2	90	150
3	3.407	3.412	.0025	.0005	0	10.2	100	220
4	3.407	3.415	.004	.0015	.002	10.2	220	90
5	3.410	3.418	.004	.001	.001	10.2	100	250
6	3.407	3.417	.005	.0005	.001	10.2	160	175

Three methods of surface preparation were used in preparing the samples:

(1) Samples 1, 3 and 5 were vapor degreased, liquid honed until free from a water break and blown dry with compressed air.

(2) Samples 2, 4 and 6 were vapor degreased, cleaned with an alkali cleaner, rinsed in cold water and blown dry with compressed air.

(3) After the treatments shown in (1) and (2) above, samples 5 and 6 were given a phosphate treatment for three minutes in Bonderite 160 and blown dry.

In all cases care was taken not to touch the joint area after cleaning.

Fifty grams of Shell Epon Adhesive VI were mixed with three grams of Shell Curing Agent A and applied to both male and female parts with a clean varnish brush. An effort was made to cover the surfaces to be joined completely while keeping the cement coating as thin as possible. The two parts were pressed firmly together by hand and rotated 360° with respect to each other to help to insure a proper distribution of cement. All excess cement was wiped off the inside and outside surfaces. These assemblies were

cured as follows:

Samples 1, 2, 5 and 6 cured at 200°F for 45 minutes.

Samples 3 and 4 cured at 165°F for 2 hours.

No pressure was applied during curing and all samples were allowed to cool to room temperature and stand for several hours before testing.

The test results are summarized here and the complete data appear in Table II.

(1) Shell Epon VI cement produced bonded joints with a shear strength in excess of 3500 psi when the joints were liquid honed prior to assembly.

(2) Liquid honing the joints prior to bonding resulted in stronger joints than when the machined surfaces were chemically cleaned only, but the actual amount of increase in strength could not be determined since the strength of the joint exceeded the strength of one of the components.

(3) Changing the curing cycle from 45 minutes at 200°F to 2 hours at 165°F resulted in no appreciable difference in the strength of the joint.

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**Table II**  
**Test Results**  
**To Test Strength of Plastic Adhesive**

Sample	Ultimate Load	Shear Load (psi)	Comments
1	37,800 lbs.	3,700	Shell body fractured. * No separation of joint.
2	33,600 lbs.	3,300	Lap separated. Air pockets in cement.
3	37,600 lbs.	3,700	Shell body fractured. * No separation of joint.
4	37,600 lbs.	3,700	Lap separated. Cement job appeared to be satisfactory.
5	33,900 lbs.	3,500	Shell body fractured. * No separation of joint.
6	26,500 lbs.	2,600	Lap separated. Cement job appeared to be satisfactory.

Sample No. 1 loaded at a rate of 2,000 lbs. per minute.

Balance of samples loaded at a rate of 4,000 lbs. per minute.

\* Cross sectional area of body at point of failure is .57 square inches, so failure of metal occurred at a stress of 66,300 psi.

## Folding Fin Projectile

A new fin assembly for folding fin type projectiles has been designed to replace the type of fin assembly used on the T119E11 projectile and on the BAT 90mm projectiles, modifications E1 through E4. The new fin assembly design is illustrated and compared with the T119E11 fin assembly (M8) design in Fig. 4.

The major objectives of the new fin assembly are as follows:

- (a) more positive locking of the fins.
- (b) fewer parts
- (c) will permit loose tolerances.

The folding fin mechanism is required to function only once, but that one performance must be such that the fins are accurately positioned and locked when open. Loose tolerances are permissible if such tolerances do not influence proper functioning. This is believed to have been accomplished in the new design.

The following design changes can be noted in Fig. 4.

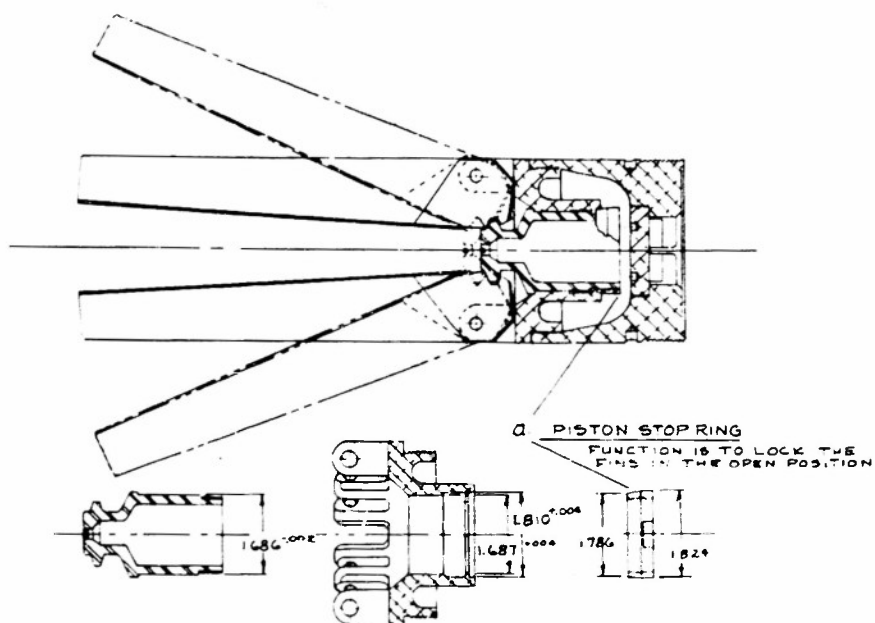
1. More positive fin locking. The function of the piston stop ring, a, in the T119E11 fin assembly (M8) is to lock the fins in the open position. In the new design the fins are locked open when the piston, b, drives past the fin lug.

2. Hinge pins have been incorporated into the fin forging. The fin can be assembled just as it comes from the forging die, thus eliminating the precision machining required on the M8 fin.

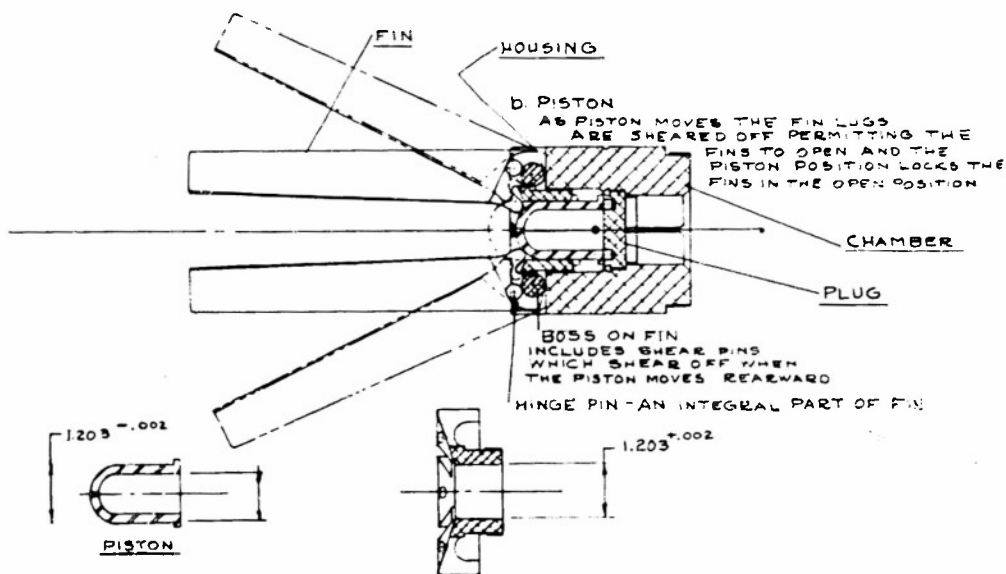
3. The fin housing and piston are designed to require a minimum of precision machining.

Future planning includes the investigation of die castings for the fin housing and a stamping for the piston which if feasible, will reduce the cost of the assembly still further.

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T119E11 FIN ASSEMBLY (M8)



90 MM BAT FIN ASSEMBLY DRC-15-860

Fig. 4. Comparison Of Fin Assembly Designs.  
T119E11 Fin Assembly (M8) and DRC-15-860 Assembly.

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## FUZES

### Potted "Lucky" Nose Element

In an attempt to improve the ground impact sensitivity of projectiles developed by Firestone, considerable attention is given to the potted "Lucky" nose element described in the Forty-Second Progress Report and illustrated in Fig. 5. A thorough dynamic test of the potted unit is scheduled for firing at Aberdeen Proving Ground during the month of May. In conjunction with this study, laboratory comparison tests have been made with the

potted unit and the package unit now in use (shown for comparison in Fig. 5).

A small pendulum was used to strike the "Lucky" units with impact velocities ranging from 2 to 9 fps and a miniature air gun was used to strike the units with impact velocities ranging from 60 to 80 fps. Curves showing a comparison of voltage output versus impact velocity and voltage output versus kinetic energy are presented in Figs. 6-9, inclusive.

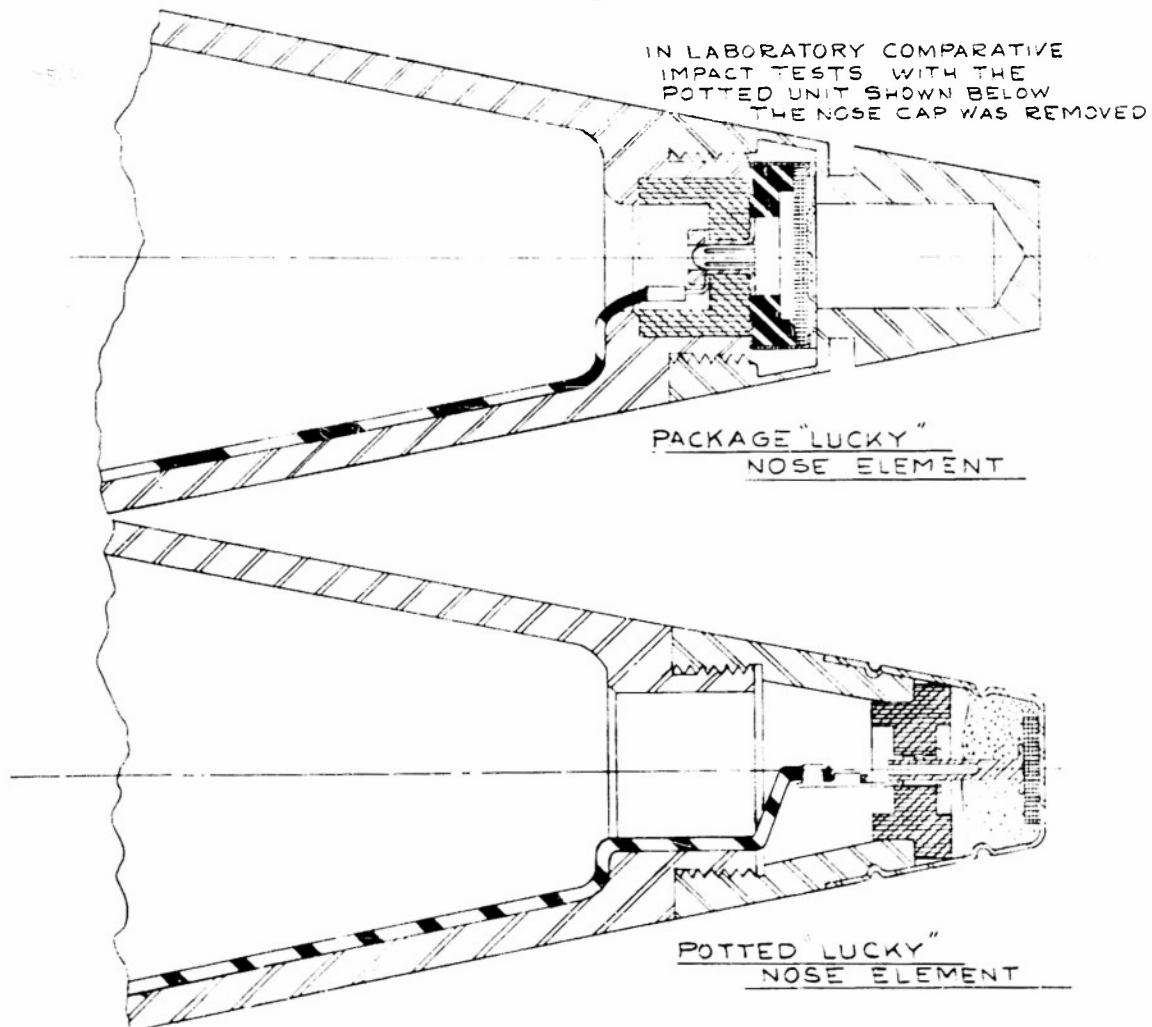


Fig. 5. Nose and Ogive Assembly.  
With Potted "Lucky" Nose Element.

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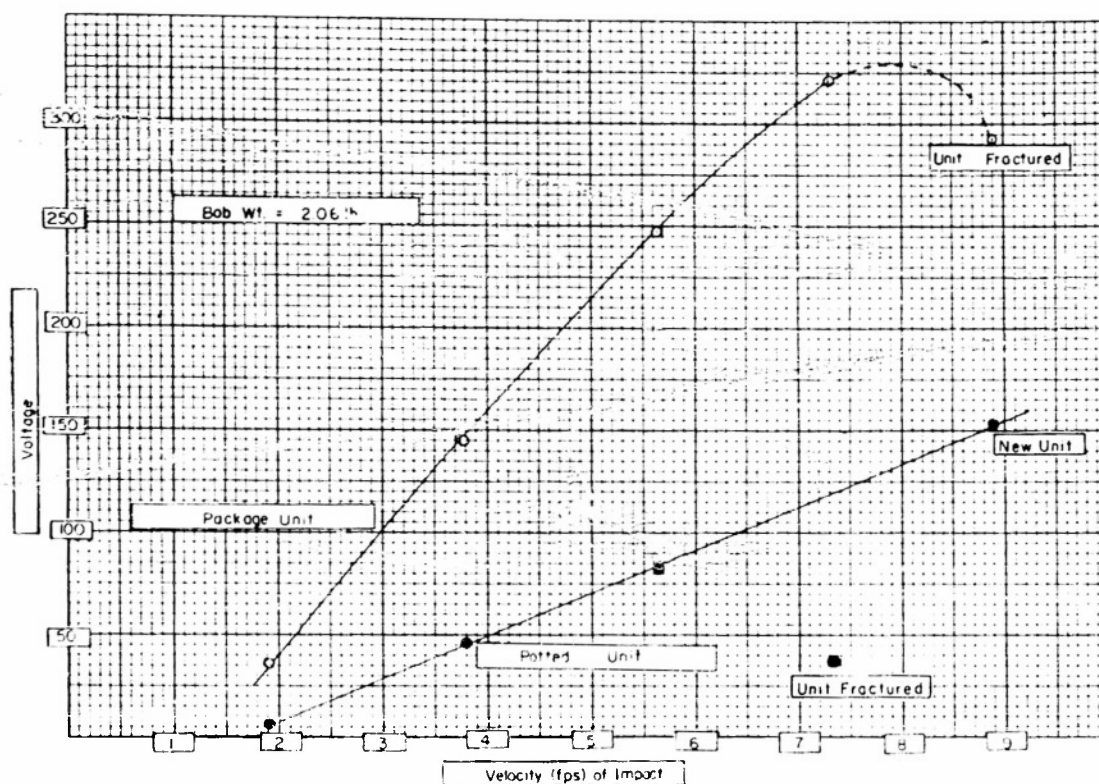


Fig. 6. Voltage Output Versus Velocity Of Impact.  
Package "Lucky" and Potted "Lucky" Units.  
Using Pendulum Impact: 2 to 9 fps Velocity.

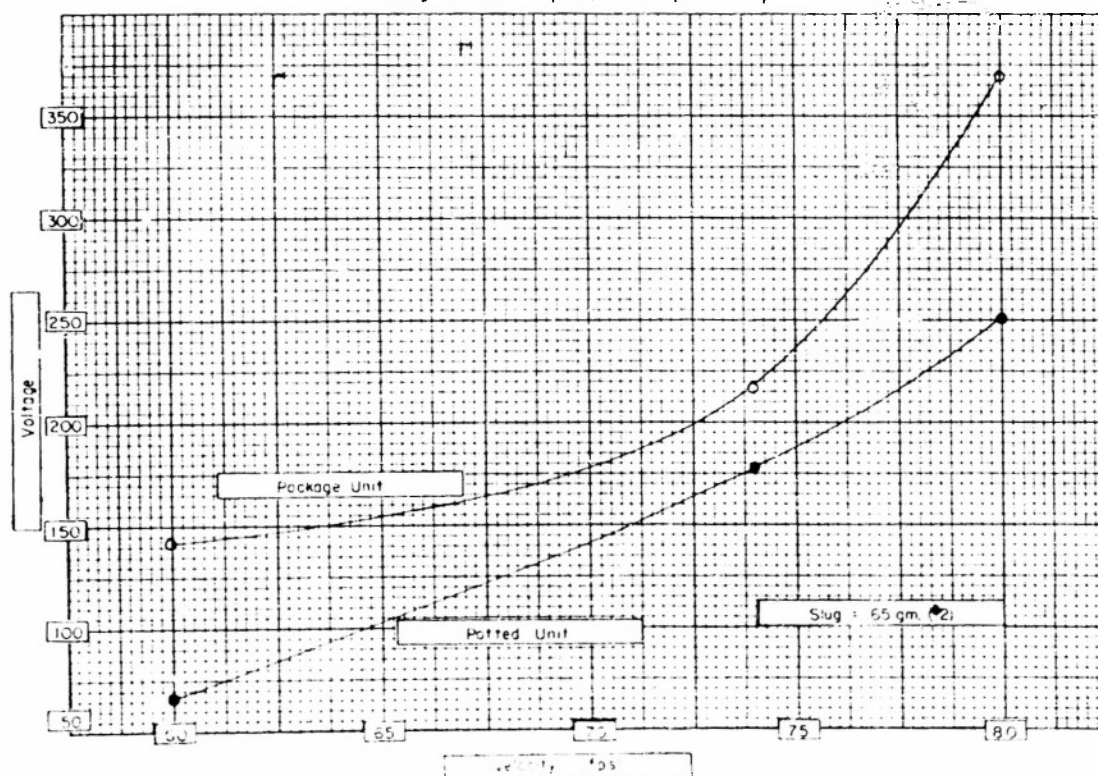


Fig. 7. Voltage Output Versus Velocity Of Impact.  
Package "Lucky" and Potted "Lucky" Units.  
Using Air Gun Impact: 60 to 80 fps Velocity.

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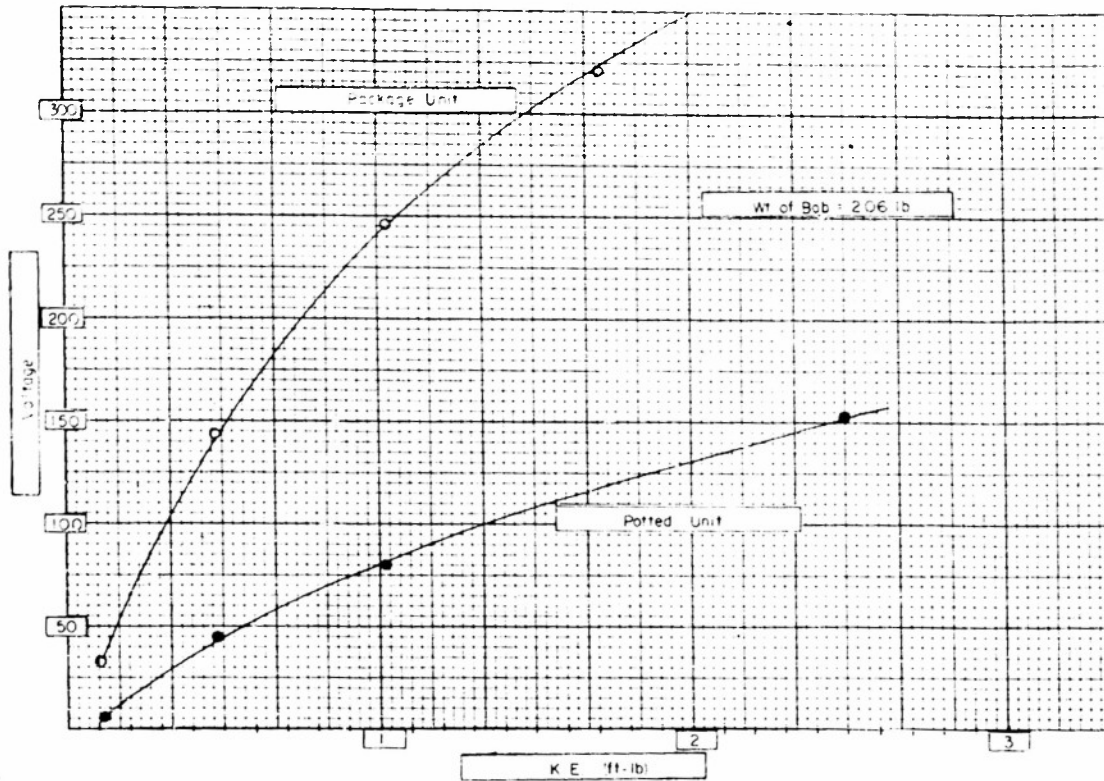


Fig. 8. Voltage Output Versus Kinetic Energy.  
Package "Lucky" and Potted "Lucky" Units.  
Using Pendulum Impact; 2 to 9 fps Velocity.

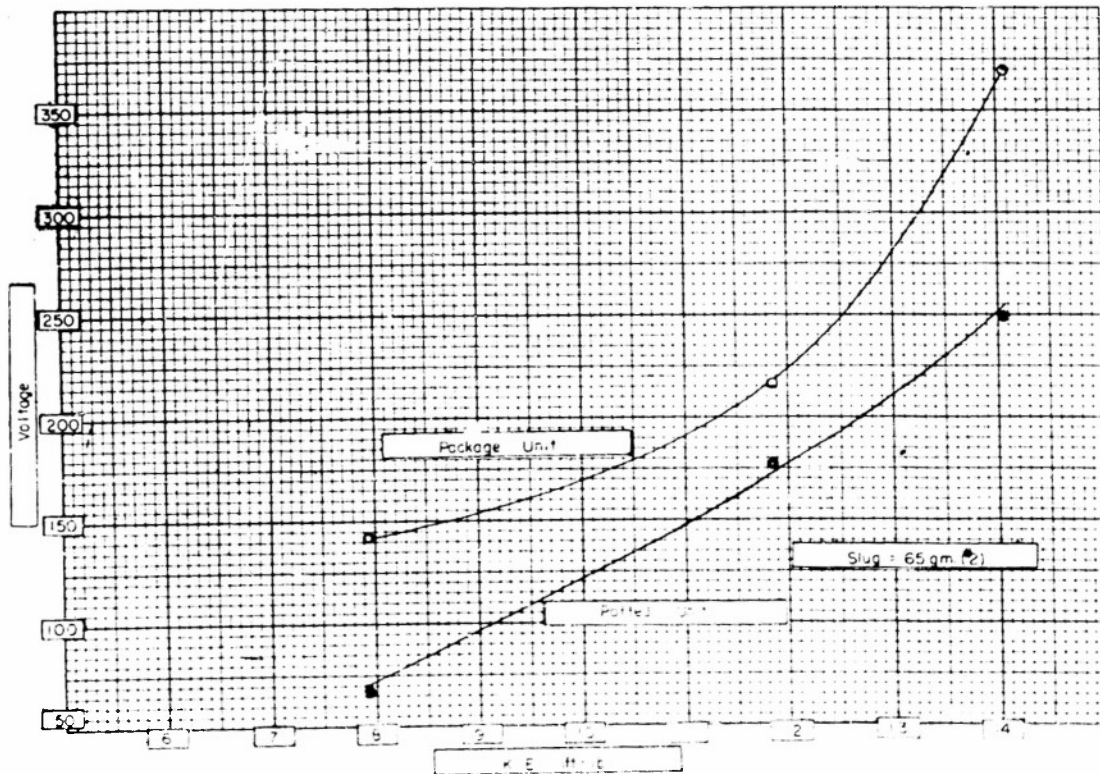


Fig. 9. Voltage Output Versus Kinetic Energy.  
Package "Lucky" and Potted "Lucky" Units.  
Using Air Gun Impact; 60 to 80 fps Velocity.

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## T267 Base Element

ing technique.

Four "delay" rounds (50%) and two rounds set "superquick" (33 1/3%) functioned satisfactorily. The remaining four rounds set "superquick" functioned "delay" and the remaining four "delay" rounds failed to function. Observation of these rounds was very poor. It is believed that the spotting charge was not sufficient for consistent observation. Table IV is a copy of the firing record. It is planned to repeat this test using an improved spott-

The base element is designed so that functioning should not occur unless the rotor has turned to the armed position (see Fig. 10). The reason for the low order functionings (Table III) is not known. The inertia element is designed to require a change of velocity of 30 fps to produce functioning. Previous tests have shown the element to function on one inch of pine.



# C O N F I D E N T I A L

**Table III**  
**Functioning Of T267E14 Base Elements**  
*On Graze Impact "Lucky" Not Connected*

Round No.	Range At Which Round Functioned	Type Of Functioning
1	1100	High Order air burst
2	1050	High Order
3	First impact - 700 ft.	High Order in woods after skipping
4	1050	High Order
5	Hit at 700 ft.	Did not function
6	Hit at 700 ft.	Did not function
7	Hit at 900 ft.	Did not function
8	Hit at 1050 ft.	Low Order
9	Hit at 1025 ft.	High Order ground blast
10	Hit at 1050 ft.	Low Order
11		Did not function. Hit in woods.
12	700	Low Order
13	470	High Order air burst
14	Hit at 350 ft.	High Order down range

## Future Program

1. Fire T267E14 base elements at Erie Ordnance Depot using improved spotting methods.

2. Fire a dynamic test of the potted

"Lucky" at Aberdeen Proving Ground.

3. Continue efforts to reduce the size of the T267 base element.



Table IV  
Test Data  
Functioning Tests With T267E14 Base Elements

Sheet 1 of 1

Date of Test 4 May 1954  
Location Erie Ordnance Depot  
Purpose of Test To Test Functioning Of T267E14  
Program No. 135  
Lot of 100 manufactured by Army Instr Co

**PROJECTILE**  
Model T119  
Type 105mm Recoilless  
Serial No. 6  
Chamber 24498-1-12931  
Bushing(s) YA884  
Tube No. 6 12742-2656-2 1/20 twist  
Sighting Equip. Telescope, Elbow, M17 No 132275  
Mount  
Type Old Field Ser No. 132275  
Constant 2.88 lb-sec/ft  
Firing Mech. Electric

**MISCELLANEOUS DATA**  
Range 24498-1-12931  
Propellant 24498-1-12931  
Type 24498-1-12931  
Lot No. 24498-1-12931  
Primer 1157  
Shell Case 15361  
Liner 1481  
Temperatures:  
Magazine Max 73°F Min 71°F Present 72°F  
Loading Room 63°F Ambient 40°F

Round Number	Proj Weight (lb)	Proj Weight (lb-oz)	Chamber Pressure (psi)	Muzzle Velocity (ft/sec)	Azim (mils)	Fuze Function	Position of Hit (inches)		Corrected Posit. of Hit - (mils)		Type Fuze	Observations
							Vert.	Horiz.	Vert.	Horiz.		
7146 1	14.50	16.68	7-14 8000	1686	1701	Yes					Delay	1 Functioned behind target
7147 2	14.48	16.64	7-14 8000	1670	1685	No					Delay	2 Not observed to function. NE in almost same
7148 3	14.41	16.65	7-14 8000	1662	1677	Yes					Delay	3 Small low cloud of smoke left to right
7149 4	14.42	16.66	7-14 8000	1683	1698	No					Delay	4 Not observed to function
7150 5	14.36	16.66	7-14 8000	1656	1671	No					Delay	5 Not observed to function. Made water splash
7151 6	14.43	16.69	7-14 8000	1628	1643	Yes					Delay	6 Small smoke behind target. Functioned just behind target
7152 7	14.45	16.68	7-14 8000	1663	1678	No					Delay	7 Not observed to function
7153 8	14.44	16.65	7-14 8000	1679	1688	Yes					Delay	8 Functioned behind target
7154 9	14.46	16.62	7-14 8000	1681	1696	Yes					Super	9 Functioned behind target. Approx at 300 yd dike.
7155 10	14.40	16.64	7-14 8000	2021	2036	Yes					Super	10 Functioned on target. 200 yds behind target.
7156 11	14.37	16.64	7-14 8000	1689	1704	Yes					Super	11 Functioned 300 yds behind, then clipped tree
7157 12	14.39	16.63	7-14 8000	1654	1669	Yes					Super	12 Functioned on and just behind target
7158 13	14.45	16.76	7-14 8000	1652	1647	Yes					Super	13 Functioned about 300 yds behind target
7159 14	14.30	16.71	7-14 8000	1650	1647	Yes					Super	14 Functioned about 100 yds behind target in air
7160 15												
7161 16	14.40	16.67										
7162 17												
7163 18												
7164 19												
7165 20												
7166 21												
7167 22												

Muzzle 5918' 50.32' 2  
Screen (Coll) Distances

Proof Director E. H. Russell Signed W. L. Russell  
Observers W. L. Russell

**C O N F I D E N T I A L**  
**MANUFACTURING SUMMARY**

In addition to the experimental material prepared for the research and development work under contracts DA-33-019-ORD-33 and DA-33-019-ORD-1202, described in preceding progress reports and in the preceding pages of this report, the following have been manufactured and shipped to the installations indicated.

Firestone's Defense Research Division, in shipping these items, transfers custody and control of the items to the receiving agencies. However, personnel of Defense Research Division will continue to collaborate with personnel of the other installations.

**I. Cartridges, HEAT, 106mm, M344 (T119E11) Without  
Fuzes T208E7**

Prior to	April 1, 1954	16,715	All Shipments
	No Shipments in April		

**II. Rifles, T170E1 for ONTOS**

Prior to	April 1, 1954	72	All Shipments
	April 17, 1954	12	Aberdeen Proving Ground
	April 24, 1954	18	Aberdeen Proving Ground
	April 30, 1954	18	Aberdeen Proving Ground
	Total	120	

**III. Mounts, T173 and T26 Tripod for ONTOS**

Prior to	April 1, 1954	22	All Shipments
	No Shipments in April		

**IV. BAT Systems less Jeep, T170E1 (M40) Rifle,  
T149E3 (M79) Mounts (with latest modifications).**

Prior to	April 1, 1954	25	All Shipments
	No Shipments in April		

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